

Date: Thursday, 9/14/2006 7:29:50 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 28570	
Estimate Number : 12168	
P.O. Number : <i>N/A</i>	Part Number : D34783
This Issue : 9/14/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3478 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 26540	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/6/2006
Checked & Approved By : <i>[Signature]</i>	Qty: 8 Um: Each
Comment : Est Rev:A New Issue 06-02-03 JLM Est Rev:B As per Rev B 06-05-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.1545 sf(s)/Unit Total: 0.6178 sf(s) *W*

Pick:

304/316 0.018 SHEET

(M304S26GA)

Batch: *M10100**1.24**FF 06.09.18 8*

2.0	SHEAR	SHEAR
-----	-------	-------

**Comment:** SHEAR

Cut Flat pattern 2.00" X 8.79" as per Dwg D3475

*?**FF 06.09.18 8*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2-Roll as per Dwg D3478

3-Form Bead as per Dwg D3478 Using Rotary Machine.

4-Spot Weld as per Dwg D3478 and Dart QSI 018

*3**FF 06.09.18 8**SB 06/09/19 8*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: SD Date: 06/12/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:29:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 28570

Part Number: D34783

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 5:26 B

11/09/09/28 (8)

5.0

~~PACKAGING~~

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Location: 444

I.O. stock

PU 6/9/27 (8)

(P70)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

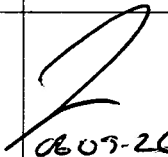
06/09/07 (8)

Job Completion



11/09/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-09-26	5.0	I.D. & stock in location: ?? make change.	E	06.10.04			 0609-26

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

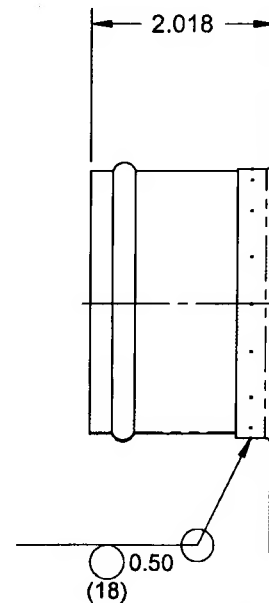
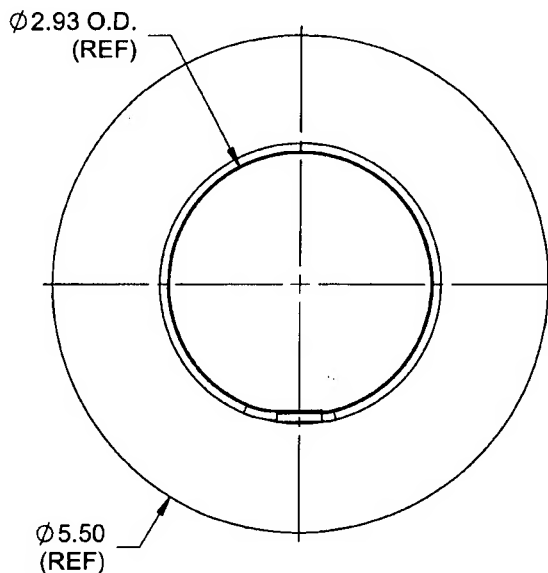
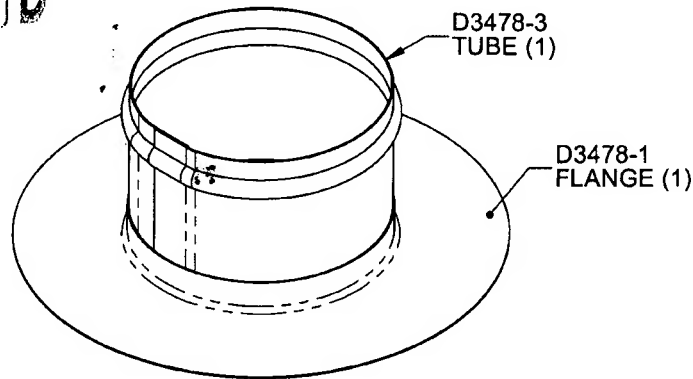
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3478	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2
A	05.12.08	NEW ISSUE	
B	06.05.16	REDESIGN D3478-5, ADD D3478-7, D3478-9S/-9	

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WORK ORDER

NO. 28570

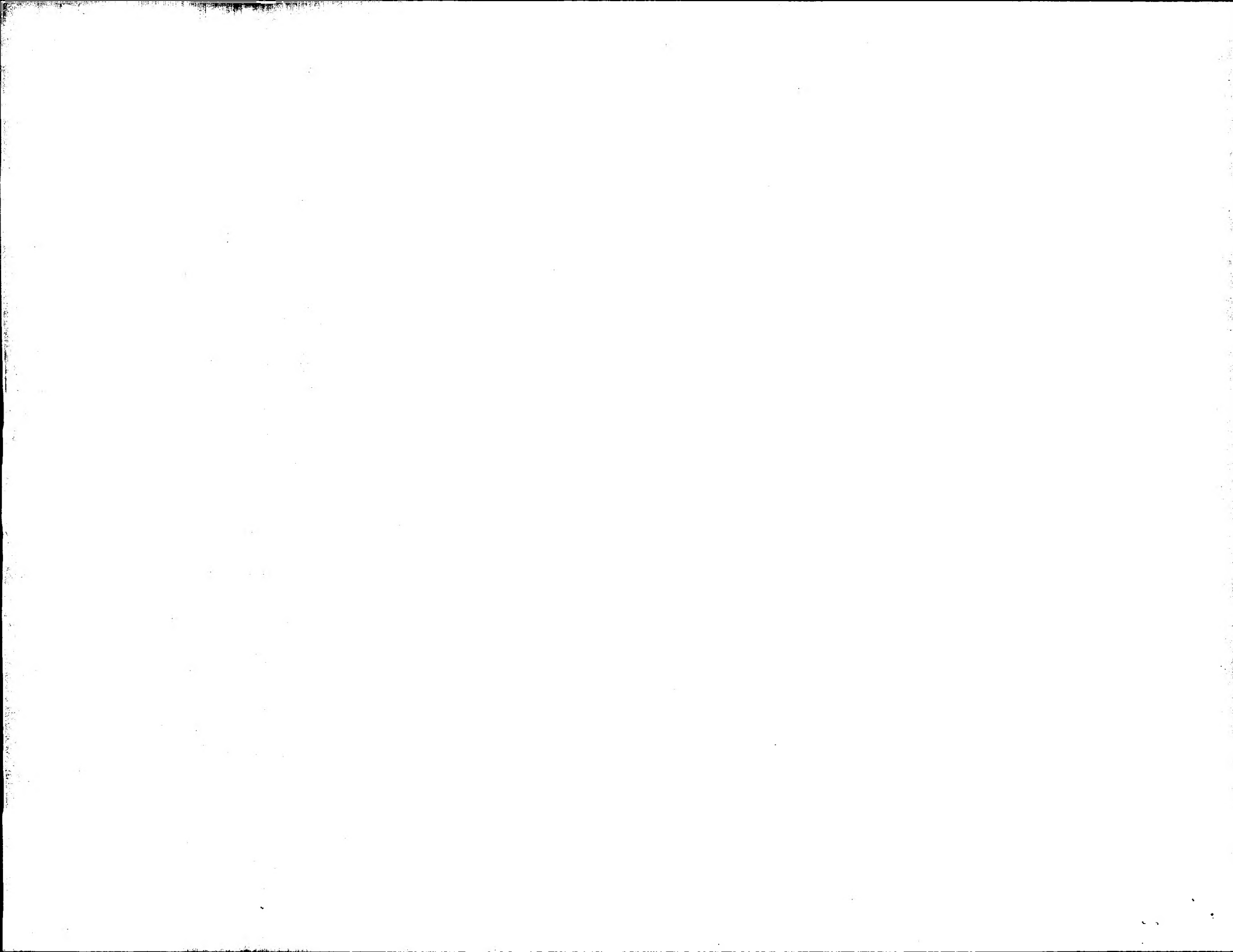
D3478-041 AIR INLET ADAPTER**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3478-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3478-041	AIR INLET ADAPTER
1	D3478-1	FLANGE
1	D3478-3	TUBE

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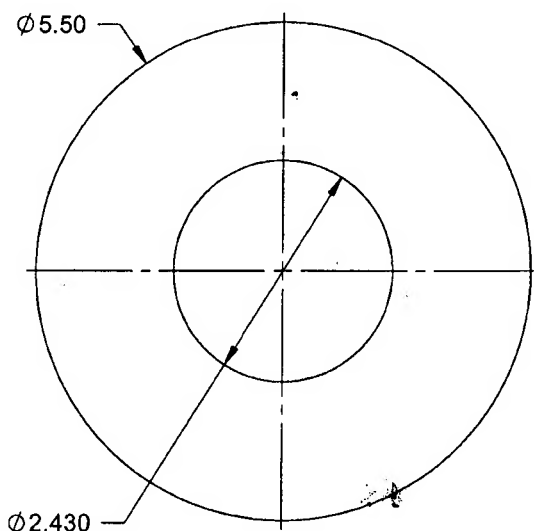
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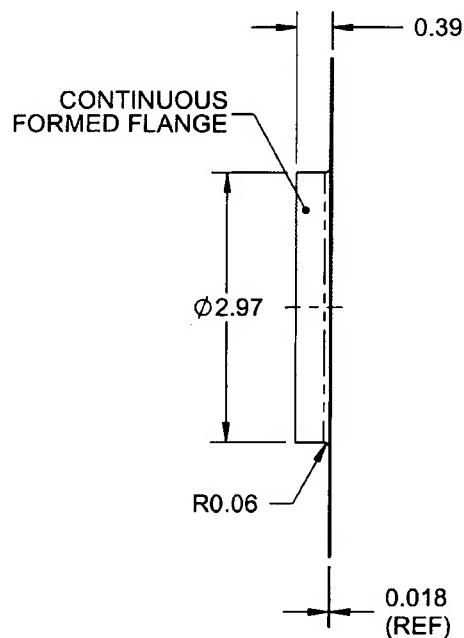


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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06-05-16 #



**D3478-1F FLANGE
FLAT PATTERN**



**D3478-1
FLANGE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

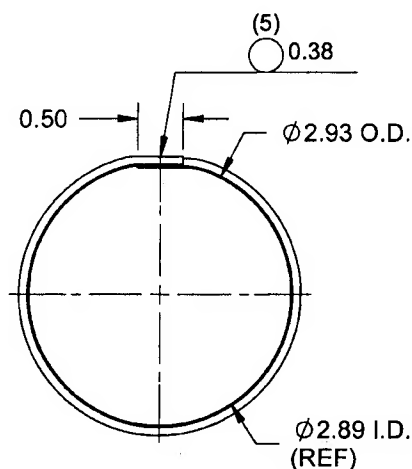
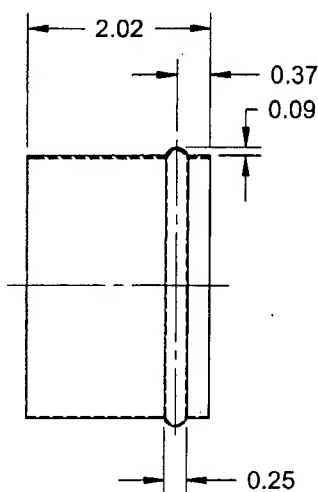
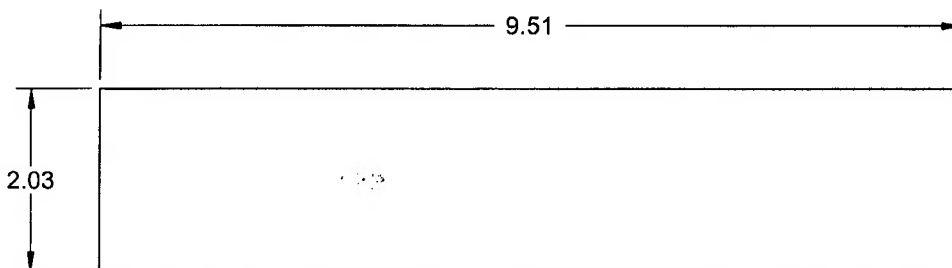
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DATE 06.05.16	TITLE AIR INLET ADAPTER		SCALE 1:2

RELEASED
06.05.16 #**D3478-3 TUBE****D3478-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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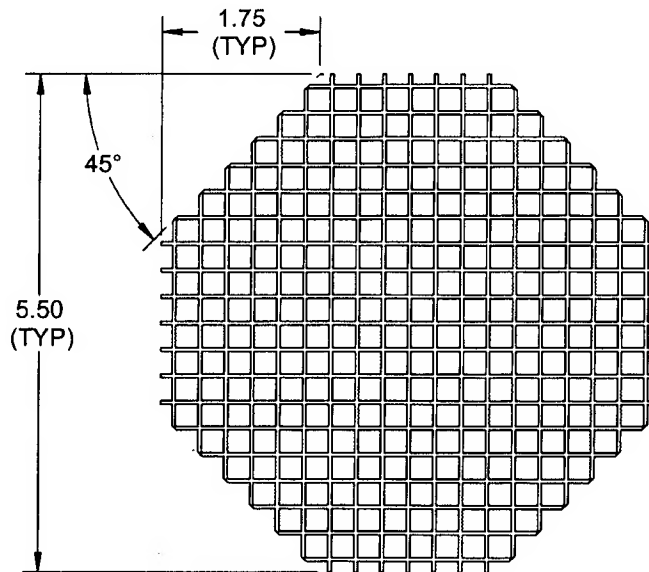
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16 *H*



D3478-5 SCREEN

NOTES:

- 1) MATERIAL: #4 MESH SCREEN, 0.203" OPENING, ϕ 0.047" WIRE
(REF. DART SPEC. M304MS4.203-.047)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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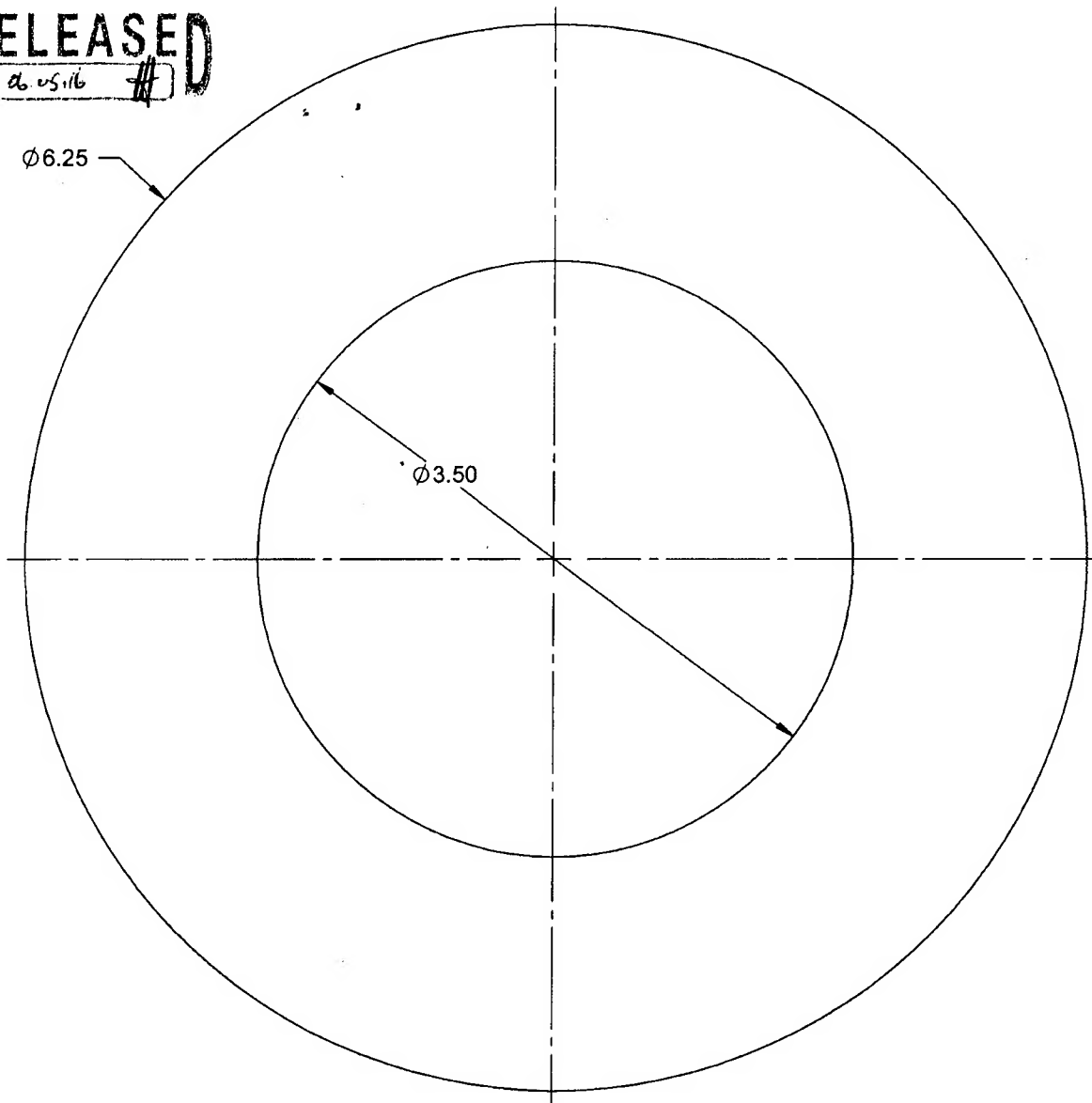
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:1

RELEASED
06.05.16 *#*



D3478-7 INLET GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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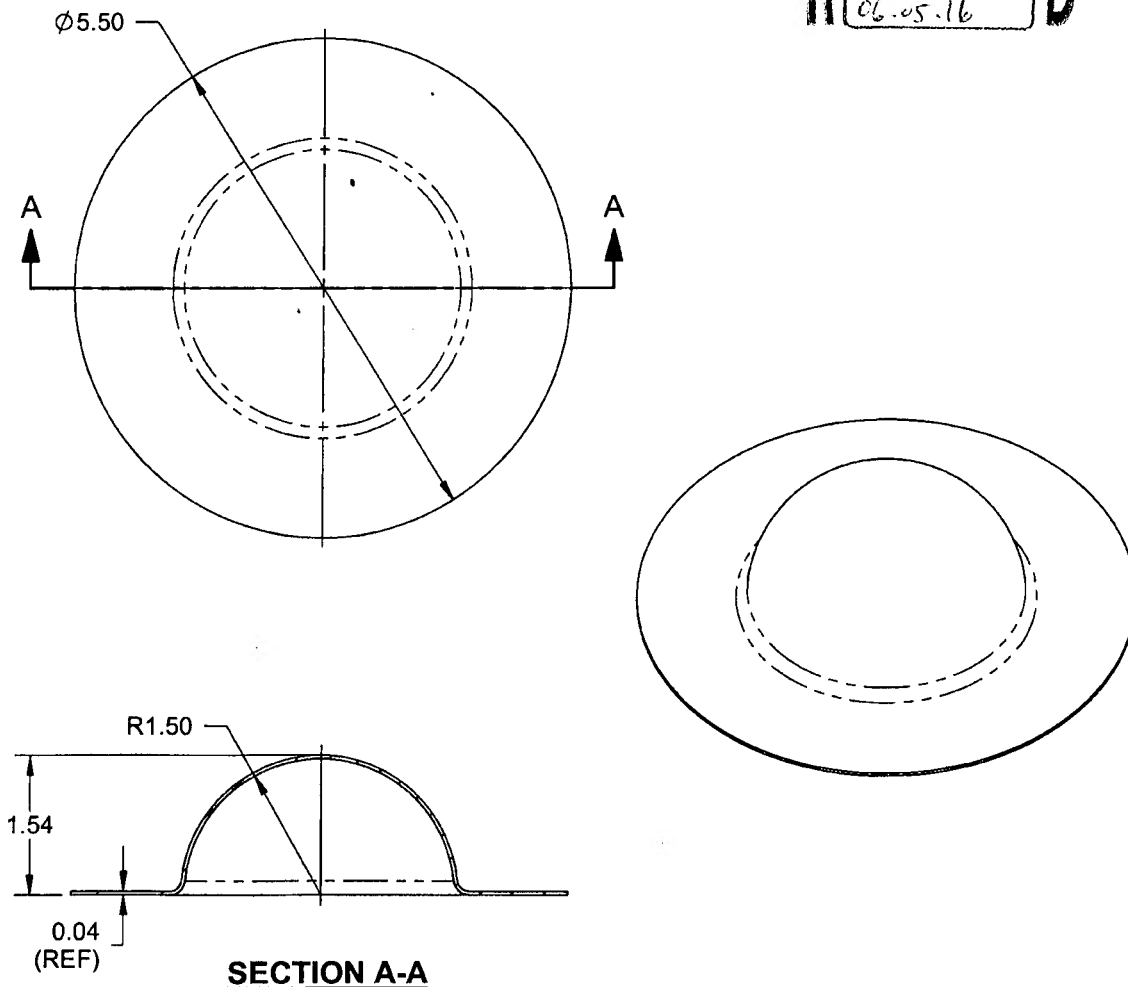
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

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06.05.16



D3478-9S AIR INLET SCOOP, SPINNING DETAIL

NOTES:

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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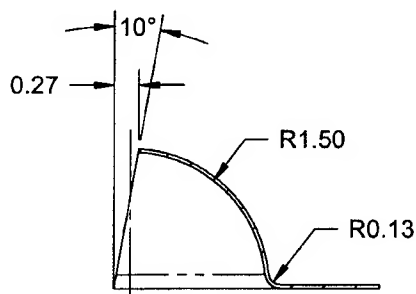
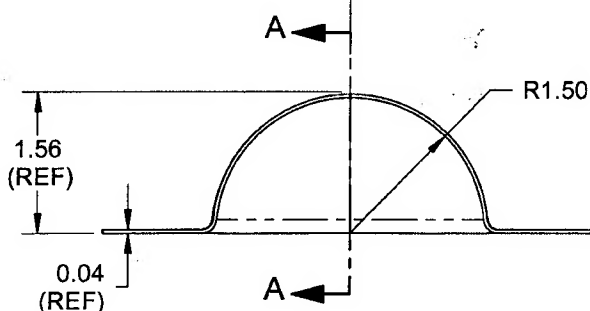
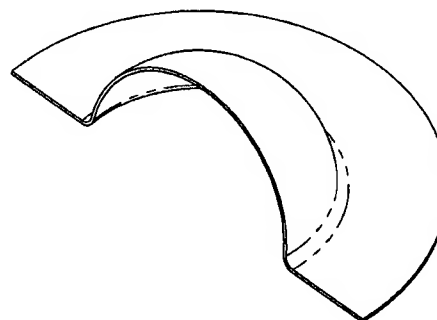
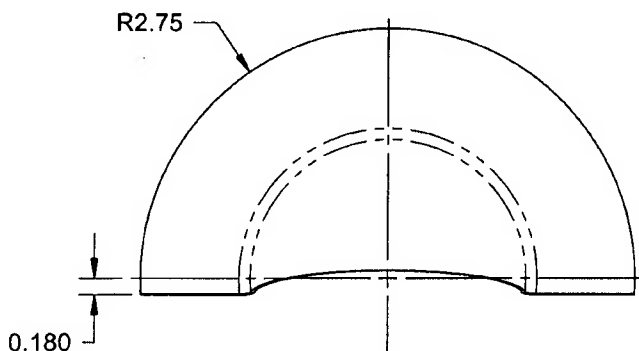
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

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06.05.16



SECTION A-A

D3478-9 INLET SCOOP

NOTES:

- 1) MATERIAL: MAKE FROM D3478-9S
- 2) IDENTIFY WITH DART P/N D3478-9 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 7

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Sylvie Boucher
Joint Welding Procedure Spot Weld
Part number and Job number B34783 / B28570

TEST WELDS REQUIRED

BASE METAL SS WELDING PROCESS Spot weld
Penetration Complete ☒ Partial ☐ Single Weld ☒ Double Weld ☐
Current AC ☐ DC ☒ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/09/19 Qualifier David David